

Ship Sept. 30

Work Order ID 73020

Wednesday, August 24, 2011 8:53:50 AM



Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 8/24/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

8 11/10/11

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

3-Grind End Plate flush

114514
117884

11.09.15

10 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date:

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Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

*10 0 BE11/09/15

130

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

S ulalib

+10
RM

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

Ac-11.09.17

*10 0

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

K11.09.28

10 ϕ

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R: Aluminum Rod 117884

6-Grind End Plate flush

7-Install last rivet as per Dwg.

K11.10.1

10 ϕ

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

8 wk/03

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8 wk/03

f10

RH

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10X ~~Ø~~ m 11/10/03
RH

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Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start



QC: Date:

SPC (Y/N): Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

START TIME: 1:30

OVEN TEMPERATURE: 320 °F

FINISH TIME: 2:00

Powder Coating

230

Wing Walk as per dwg QSI005 4.4 Batch 118313 0.00



HandFinish

Memo

0.00

Hand Finishing

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10x φ M / 11/10/03

10 BA 11-10-3.

10 RM φ M / 11/10/03

M 118439

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

Split 10-04

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/24/04



270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312
Location: _____

8/24/04

W/O:		WORK ORDER CHANGES								
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Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/04

MK

11-09-04

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DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Wednesday, August 24, 2011 8:53:46 AM

Page 1

Work Order ID: 73020

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH


Start Date: 8/24/2011

Required Date: 9/30/2011


Start Qty: 10.00

Required Qty: 10.00


Comments: IPP Rev:A 10.04.03.22 New issue 13KJ/RF1
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:cC IPP Rev:D
 fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1 		Manufactured	No			110	Each	10.0000	1	10		11.09.13	
Step													

Location	Loc Qty	Loc Code
WA B3272	10	
71963	10	
<u>B73026</u> = 10	110	

D3067-1 		Manufactured	No					54.0000	1	10		11.09.13	
End Plate													

Location	Loc Qty	Loc Code
WA <u>B73404</u>	53	
67582	2	
70700	51	
WA016	1	
68214	1	

D3219-1 		Manufactured	No			110	Each	88.0000	2	20			
Plate													

Location	Loc Qty	Loc Code
WA	48	
72128	48	
WA017	40	
<u>68338</u>	40	

11.09.14

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 8/24/2011

Required Date: 9/30/2011

Start Qty: 10.00

Required Qty: 10.00

D3066-1 Manufactured No
Spacer

180 Each

87.0000

2

20

Location

Loc Qty

Loc Code

WA

87

70699

87

20

MS20600-AD4W4 Purchased No
Rivets

180 Each

1,520.000

16

160

Location

Loc Qty

Loc Code

ST321

1515

116188

59

117364

1000

117601

200

117885

195

118267

61

WA018

5

116712

5

D3065-041 Manufactured No
Step Leg Assembly Hi

180 Each

0.0000

1

10

D3067-1 Manufactured No
End Plate

180 Each

54.0000

1

10

Location

Loc Qty

Loc Code

WA

B73404

53

67582

2

70700

51

WA016

1

68214

1

10

Wednesday, August 24, 2011 8:53:47 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 8/24/2011

Required Date: 9/30/2011

Start Qty: 10.00

Required Qty: 10.00

AN3-35A

Purchased

No

250

Each

157.0000

2

20



Bolt



SP

Location

Loc Qty

Loc Code

ST353

157

117619

3

117794

14

118112

40

118451

50

118628

50

20x

D3235-1

Manufactured

No

250

Each

177.0000

2

20



Mounting Lug



SP

Location

Loc Qty

Loc Code

ST471

77

69837

77

ST481

100

71965

100

10x

10x

D3278-041

Manufactured

No

250

Each

26.0000

1

10



Support Assembly



B 72132 10x SP

Location

Loc Qty

Loc Code

ST471

26

69741

26

AN960JD416

NAS1149D0463J

Purchased

No

250

Each

0.0000

16

160



Washer



m118384 160x SP

AN960JD516

NAS1149D0563J

Purchased

No

250

Each

0.0000

4

40



Washer



m118206 40x SP 11-09-2

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Page 3

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Page 4

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 8/24/2011

Required Date: 9/30/2011

Start Qty: 10.00

Required Qty: 10.00

AN5-36A

Purchased

No

250

Each

157.0000

2

20



Bolt



m 118838 SP

Location

Loc Qty

Loc Code

ST341

157

117794

7

118012

50

118451

100

D2618

Manufactured

No

250

Each

132.0000

2

20



Bushing



SP

Location

Loc Qty

Loc Code

ST019

132

70702

28

71600

104

D2230-3

Manufactured

No

250

Each

304.0000

4

40



Lug



SP 11-09-26

Location

Loc Qty

Loc Code

ST

220

70694

20

71964

100

72125

100

ST476

4

53881

4

ST480

80

70973

80

40x

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 8/24/2011

Required Date: 9/30/2011

Start Qty: 10.00

Required Qty: 10.00

D2856-400

Manufactured No

250 f

254.7845 1.2 12



Abraison Strip



SP

Location

Loc Qty

Loc Code

ST403

38.1149

68076

38.1149

ST409

216.6696

63735

0.6696

71164

216

12x

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased No

250 Each

1,835.000 2 20



Nut



SP

Location

Loc Qty

Loc Code

ST300

1835

117441

190

117601

400

117885

245

118451

1000

26x

AN4-13A

Purchased No

250 Each

1,006.000 8 80



Bolt



m11f706 80x sp 11-09-26.

Location

Loc Qty

Loc Code

ST357

1006

117962

4

118078

594

118350

108

118351

300

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Start Date: 8/24/2011

Required Date: 9/30/2011

Start Qty: 10.00

Required Qty: 10.00

MS21042L5

Purchased

No

250

Each

1,153.000

2

20



Nut



SP

Location

Loc Qty

Loc Code

ST300

1153

116105

5

116548

53

117441

494

117591

15

117611

90

118179

496

20x

MS21042L4

Purchased

No

250

Each

4,539.000

8

80



Nut



SP

Location

Loc Qty

Loc Code

ST300

4539

117441

394

117601

645

117885

1500

118451

2000

80x

AN960JD10

NAS1149D0363J Purchased

No

250

Each

0.0000

4

40



Washer



m 118077 40x

SP11-09-26.

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DESIGN <i>qp</i>	DRAWN BY <i>js</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG SCALE NTS	
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

△
B

GENERAL NOTES:

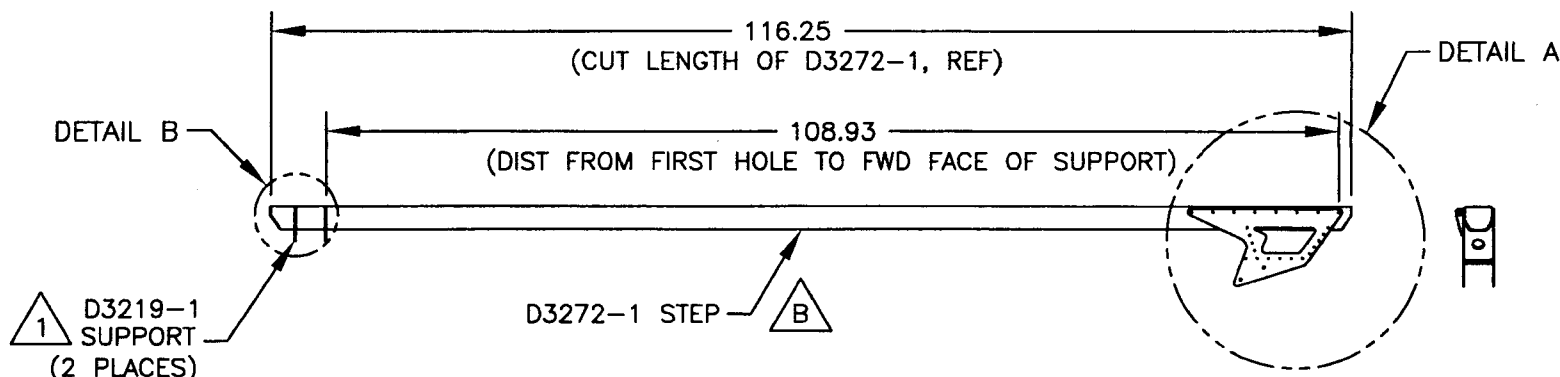
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

73020

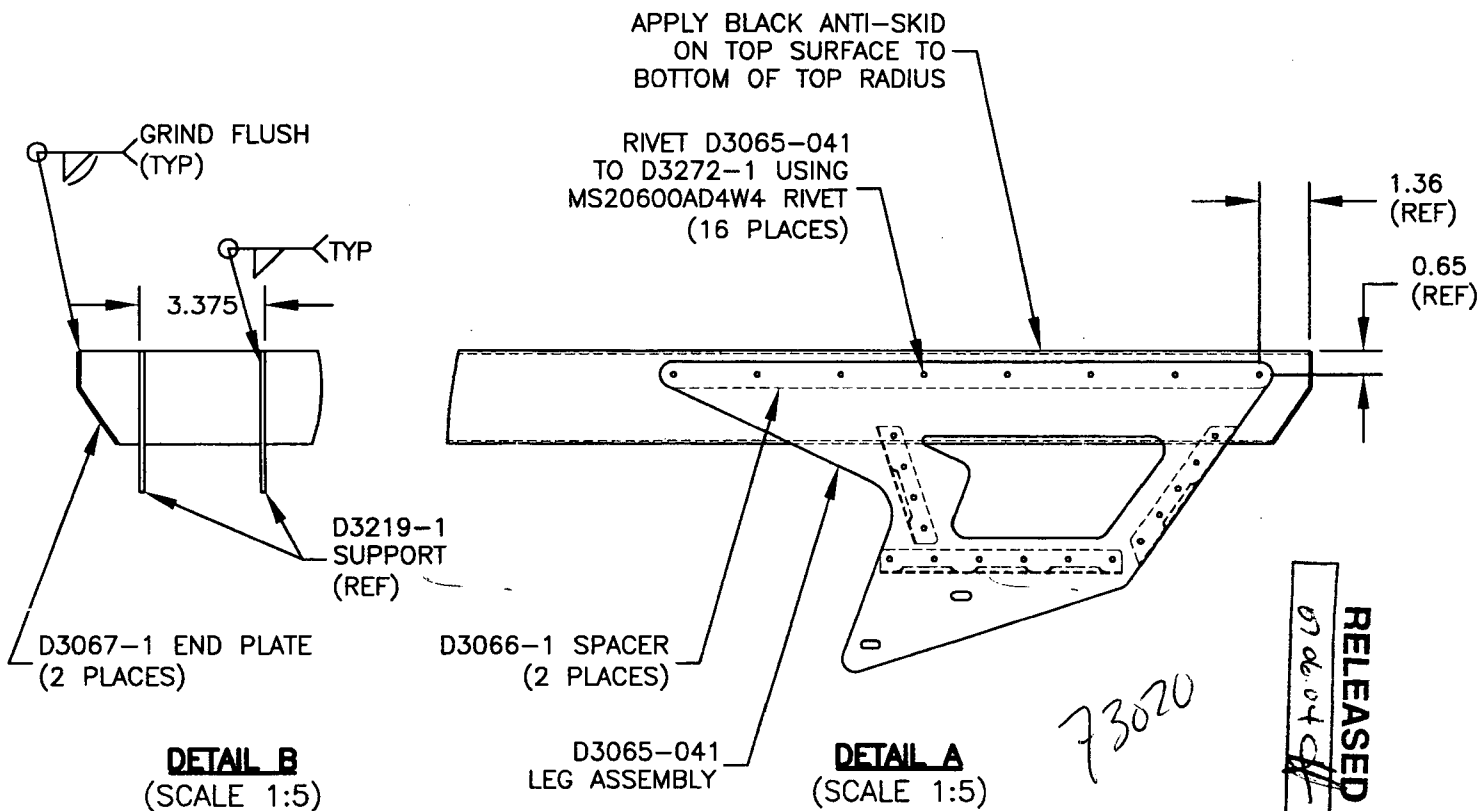
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DART



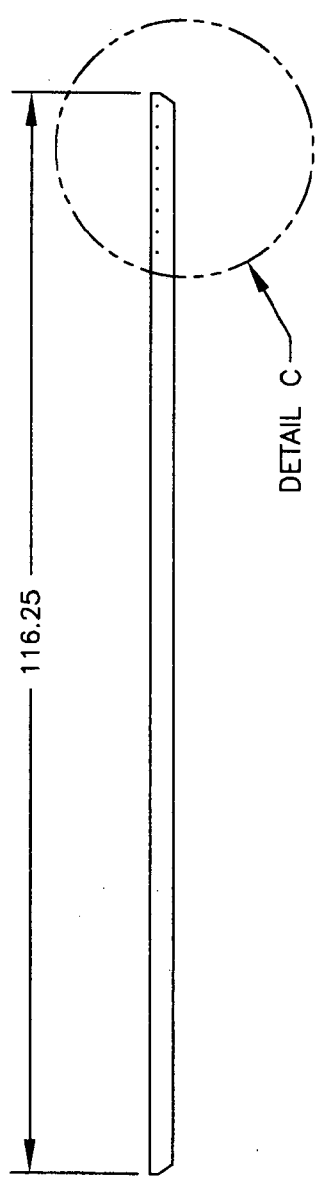
D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DESIGN	49	DRAWN BY	73020	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	APPROVED	[Signature]	DRAWING NO.	D3272
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3	SCALE 1:20

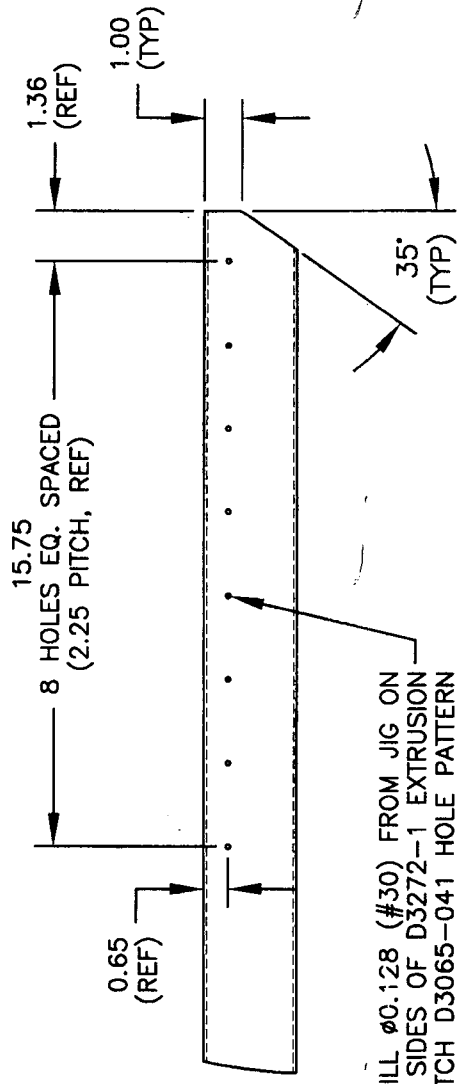


DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



DETAIL C

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

RELEASED

07.06.04 *[Signature]*

make

DART AEROSPACE LTD.

D350-591
Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™ , Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™ , Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™ , Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™ , Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™ , Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™ , Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™ , Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™ , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.